

Work Order ID 150220

Tuesday, December 06, 2016 9:06:48 AM

150220

Reprint

Testing

Page 1

Item ID: D412-664-203

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Crosstube - High

Start Date: 8/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

1

Customer:

Reference: RD16-682-01

Approvals:

Process Plan:

DAS
21

Date: DEC 06 2016

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp~~Draw Nbr~~

Revision Nbr

D412-664-243

F

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 010

N/A 9/10/12/16

110

Packaging

0.00

110

Packaging

Memo

0.53

Packaging

N/A 9/10/12/16

TW

16-10-25

120

BENDING MACHINE - CROSSTUBES

0.05

120

CNC Bend 2

Memo

0.17

CNC Alpha 160 Bender

Bend tube as per Dwg D412-664-243 using CNC bender program 412-aft and Folio FT010

TW

16-10-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

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Page 2

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Revision ID:

Stop ***NS2***

Item Name: Aft Crosstube - High

Start Date: 8/18/2016 Start Qty: 1.00

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Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

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Customer:

Reference: RD16-682-01

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC15- Crosstube Dimensional Check

0.00

130

QC

Memo

0.00

Quality Control

140

140

Crosstubes

Crosstubes

0.00

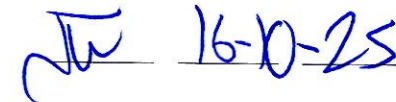
Memo

0.21

Crosstubes

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #
ACCORDING TO NOTE 64- *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr
& Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Work Order ID 150220***150220***

Page 3

Tuesday, December 06, 2016 9:06:48 AM

Item ID: D412-664-203

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Crosstube - High

Start Date: 8/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

1

Customer:

Reference: RD16-682-01

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

HandFXtube

Memo

0.08

Hand Finishing Crosstubes

IMMEDIATELY AFTER GRINDING

1- PRESSURE WASH X-TUBE INSIDE AND OUT

2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

 16-10-25

165

QC7-Inspect Chemical Conversion Coat

0.00

165

QC

Memo

0.00

Quality Control

DP2 16-10-25

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

INSPECT ENGRAVING AND BATCH # _____

   DAS 12 9-89 16/11/9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Work Order ID 150220***150220***

Page 4

Tuesday, December 06, 2016 9:06:48 AM

Item ID: D412-664-203 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Crosstube - High
Start Date: 8/18/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: RD16-682-01

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1 Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: <u>34132</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	0.00 30.00				<u>1</u>	<u>0</u>	<u>0</u>	DAS 12 9-89 16/11/9
190 *190* Packaging Packaging Packaging	Packaging Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for transit damage Ensure copy of NDT results attached to work order.	0.00 0.02							DAS 12 9-89 16/11/9
200 *200* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D412-664-203	0.00 0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : <u>16/11/6</u>		Step #: <u>190</u>		QTY Effective :			MRB (QSI042) Approval <u>DAS</u> <u>12</u> <u>9-89</u> <u>14/11/6</u>		
Description Work Order Deviation				Disposition					
<i>Original w/o wcr lost along with NDT Report. Crustube passed, however, crustube is for testing only. NDT only required for information purposes only.</i>				<i>Not required for test.</i>				Completed By <u>DAS</u> <u>12</u> <u>9-89</u> <u>16/11/6</u>	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 150220***150220***

Page 5

Tuesday, December 06, 2016 9:06:48 AM

Item ID: D412-664-203

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Crosstube - High

Start Date: 8/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

1

Customer:

Reference: RD16-682-01

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

0.00

210

SprayPaint

SprayPaint

Memo

0.08

Spray Painting

*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE ***

**VERIFY BY _____ BATCH # TO MATCH W/O _____

***VERIFY BY _____ PART # TO MATCH

W/O _____

MASK SCRIBE B# & P# AND VERIFY

~~***Mask underside of crosstube as shown***~~

No Window

1-Prime inside and outside crosstube as per QSI 005 4.2 AND DWG

PRIMER: 135953

START TIME: _____

FINISH TIME: _____

2-Paint outside crosstube with White Imron as per DWG D412-664-243 and QSI 005 4.2

PAINT: 136040

Start Time: _____

Finish Time: _____

3- Apply clear coat after paint as per DWG


PTD
16-12-06

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☒ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : <u>16/12/16</u>	Step #: <u>210</u>	QTY Effective : <u>1</u>		MRB (QSI042) Approval <u>DAS</u> <u>12</u> <u>9-89</u>	
Description Work Order Deviation		Disposition		Completed By	
<u>Do not print clear "window".</u> <u>Print only 6" wide (approx) region around</u> <u>center support</u>		<u>FOR TESTING ONLY</u>		Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 150220***150220***

Page 6

Tuesday, December 06, 2016 9:06:48 AM

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 8/18/2016 Start Qty: 1.00

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Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

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Customer:

Reference: RD16-682-01

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC14- Inspect Spray Paint

0.00

220

QC

Memo

0.00

Quality Control

Then, Wrap in plastic bag to protect from scratches

① 16-12-07

DAS
9
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Work Order ID 150220***150220***

Page 7

Item ID: D412-664-203

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Crosstube - High

Start Date: 8/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

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Customer:

Reference: RD16-682-01

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00

230

Crosstubes

Crosstubes

Memo

0.21

Crosstubes

Assemble as per Dwg D412-664-203

1- Install center support using scoth-weld DP460 per QSI 015, as per DWG. note 13. Install supports clamps using as per Dwg D412-644-243. Install clamp with rubber cushion as per DWG. note 14. ***ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT*** Torque clamps on support to 80-100 IN-LBS AS PER DWG.

A/R scoth-weld DP460

BATCH #: 134469
EXP DATE: 4/17

2- **IF NOT ALREADY PRESENT ON CHAFFING SHEILD.** Apply a thin coat of proseal 890 per QSI 015 on inside concave surface of chafing shield and let cure per manufacturer's instructions. Install prosealed chafing shield onto crosstube by applying a thin coat of proseal 890 onto crosstube. Be sure to eliminate any air gaps. Install and torque clamps on chafing shield to 40-50 IN-LBS AS PER DWG.

A/R Proseal 890

Batch: 136076
EXP DATE: _____

AFTER FINISH CURE TIME 24H

START CURE TIME: _____

FINISH CURE TIME: _____

→ min 2 weeks 9/14/17

PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER CURED FOR 24H.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER :																																																																									

Work Order ID 150220

Tuesday, December 06, 2016 9:06:48 AM

150220

Page 8

Item ID: D412-664-203

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Crosstube - High

Start Date: 8/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

1

Customer:

Reference: RD16-682-01

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED
FOR 24HOURS AS PER DWG.***① 16-12-07 **DAS**
9
9-89

250

Pick Kit

0.00

250

Packaging

Memo

0.04

Packaging

N/A QP 10/12/16

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

N/A QP 16/12/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
BAC e P3-2									
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
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Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Work Order ID 150220

Tuesday, December 06, 2016 9:06:48 AM

150220

Page 9

Item ID: D412-664-203

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Crosstube - High

Start Date: 8/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

1

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Reference: RD16-682-01

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27
for application time & date *****

Time & date of packaging: _____

Location: _____

N/A 9/16/12/16

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.02

Quality Control

RD16-682-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																					

Picklist Print

Tuesday, December 06, 2016 9:06:51 AM

Work Order ID: 150220

150220

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Aft Crosstube - High

Start Date: 8/18/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:
 IPP Rev:E04.02.16Reformat; Added D3189-1K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 06.12.08 per ECN 886 EC
 IPP Rev:H 07-04-30 As per Rev D JLM
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J
 11.04.21 DEO D412-664-243-E-1 EC verified DD IPP REV:K
 11.10.03 DEO D412-664-243-E-2 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-664-203TRN		Manufactured	No			110	Each	0.0000	1	1			
D412-664-203TRN									**				
Crosstube Turning Detail													
D2896-1		Manufactured	No			230	Each	9.0000	1	1			
D2896-1									**				
Support													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG051				9					
				148418				9					
D3189-1		Manufactured	No			230	Each	18.0000	2	2			
D3189-1									**				
Chaffing Shield													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG051				18					
				152176				10					
				152739				8					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Picklist Print

Tuesday, December 06, 2016 9:06:51 AM

Page 2

Work Order ID: 150220

150220

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Aft Crosstube - High

Start Date: 8/18/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3595-063-570

Manufactured No

230 Each

55.0000 2 2

D3595-063-570

Rubber Cushion 0.63" wide x 5.70" Long

Location

Loc Qty

Loc Code

FG

8

42243

8

LG052

47

144834

19

152228

28

MS21920-28

Purchased No

230 Each

51.0000 4 4

MS21920-28

Clamp

Location

Loc Qty

Loc Code

FG

1

105884

1

LG050

41

M135859

41

LG051

1

M132169

1

LG057

2

M134130

2

st543

6

M135009

6

MS21920-30

Purchased No

230 Each

27.0000 2 2

MS21920-30

Clamp

Location

Loc Qty

Loc Code

LG57

27

m134257

7

m135127

20

Tuesday, December 06, 2016 9:06:51 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY			
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Picklist Print

Tuesday, December 06, 2016 9:06:51 AM

Page 3

Work Order ID: 150220

Parent Item: D412-664-203

Parent Item Name: Aft Crosstube - High

150220

D412-664-203

Start Date: 8/18/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

AN6-40A

Purchased

No

250

Each

131.0000

4

4

AN6-40A

3/8-24 Bolt X 3" Long

Location

Loc Qty

Loc Code

over005

95

M135948

30

M135979

30

M136295

35

ST333

36

M133769

4

M134509

2

M135297

30

AN6-41A

Purchased

No

250

Each

44.0000

2

2

AN6-41A

Bolt

Location

Loc Qty

Loc Code

over005

40

M135767

20

M135966

20

ST333

4

M134508

4

MS21042L6

Purchased

No

250

Each

314.0000

6

6

MS21042L 6

Nut

Location

Loc Qty

Loc Code

OVER007

150

m135979

100

m136295

50

ST303

164

m135704

64

m135864

100

Tuesday, December 06, 2016 9:06:51 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Tuesday, December 06, 2016 9:06:51 AM

Page 4

Work Order ID: 150220

150220

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Aft Crosstube - High

Start Date: 8/18/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0663J

Purchased

No

250

Each

1,236.000

18

18

NAS1149D0663.J

Washer

Location

Loc Qty

Loc Code

ST260a

1100

M135948

500

M136192

600

ST263

136

M135464

136

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

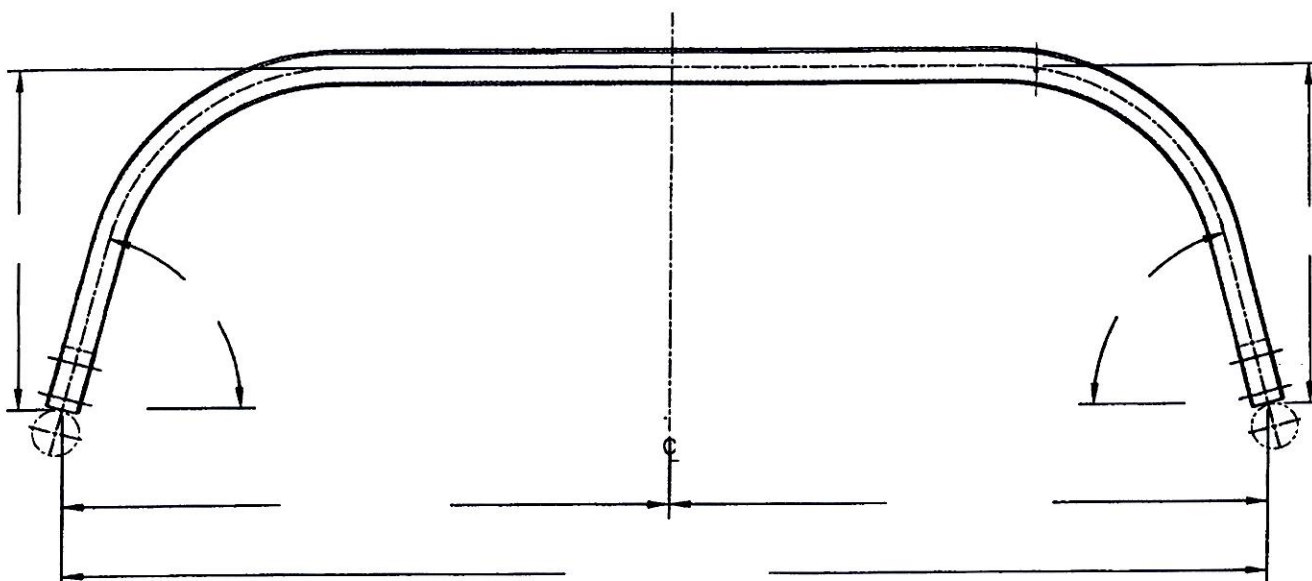
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD	Work Order: 150220
Description: Crosstube High Aft (412)	Part Number: D412-664-203
Inspection Dwg: D412-664-243 Rev: F	Page 1 of 1

Required Dimension	Min	Max
Height	24.12	24.62
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70
Bending Passes	8	--
Crushing	--	7%



	Side A	Side B
Bending Passes		
Crushing		
Comments		

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.09.08	Max crushing % revised	KJ	

Item	Qty	Part Number	Description
	-243		
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
10	A/R	PROSEAL 890 B-2	SEALANT

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING)
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2, HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, REMOVE MASKING AND APPLY MATTE CLEAR COAT
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: DART P/N "D412-664-243" AND B/N ON INSIDE OF CUFF PER QSI 044 6.4 (VIBRATING STYLUS)
- WEIGHT: 47.0 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. DO NOT GRIND TUBE AFTER SHOT PEEN.

TURNING

- WHEN TRANSITIONING TO STOCK MAT'L, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7% (BASED ON O.D.) IN LOWER HALF OF R30 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.

ASSEMBLY

- INSTALL D2896-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015.
- INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEAL 890 ON INSIDE CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- TORQUE CLAMPS ON D2896-1 SUPPORT 80 TO 100 IN.-LB. TORQUE CLAMPS ON D3189-1 CHAFING SHIELD 40 TO 50 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVES HAVE CURED FOR 24 HOURS.

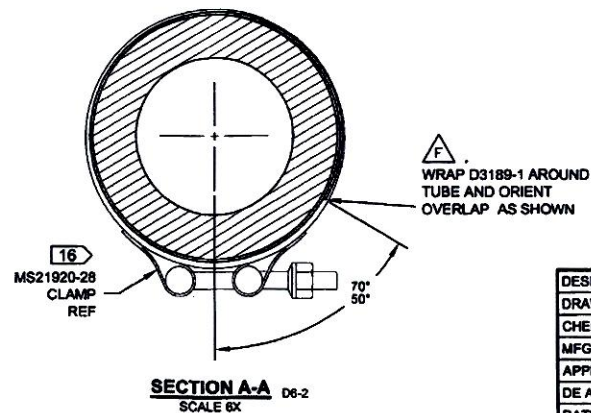
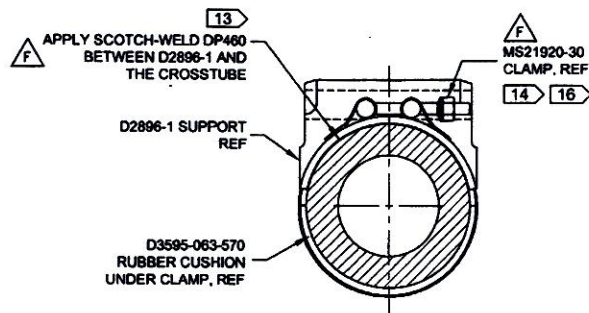
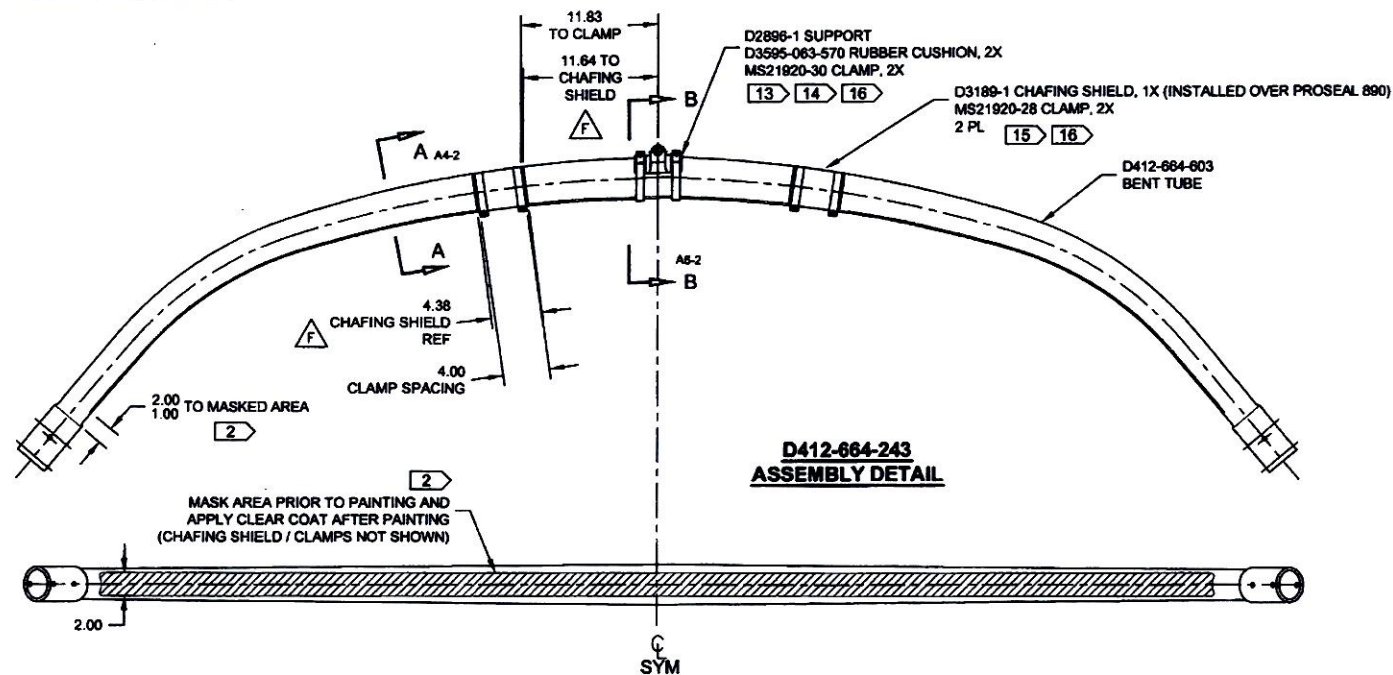
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 150220 MLJ
15/12/06

RELEASED
2014-05-26

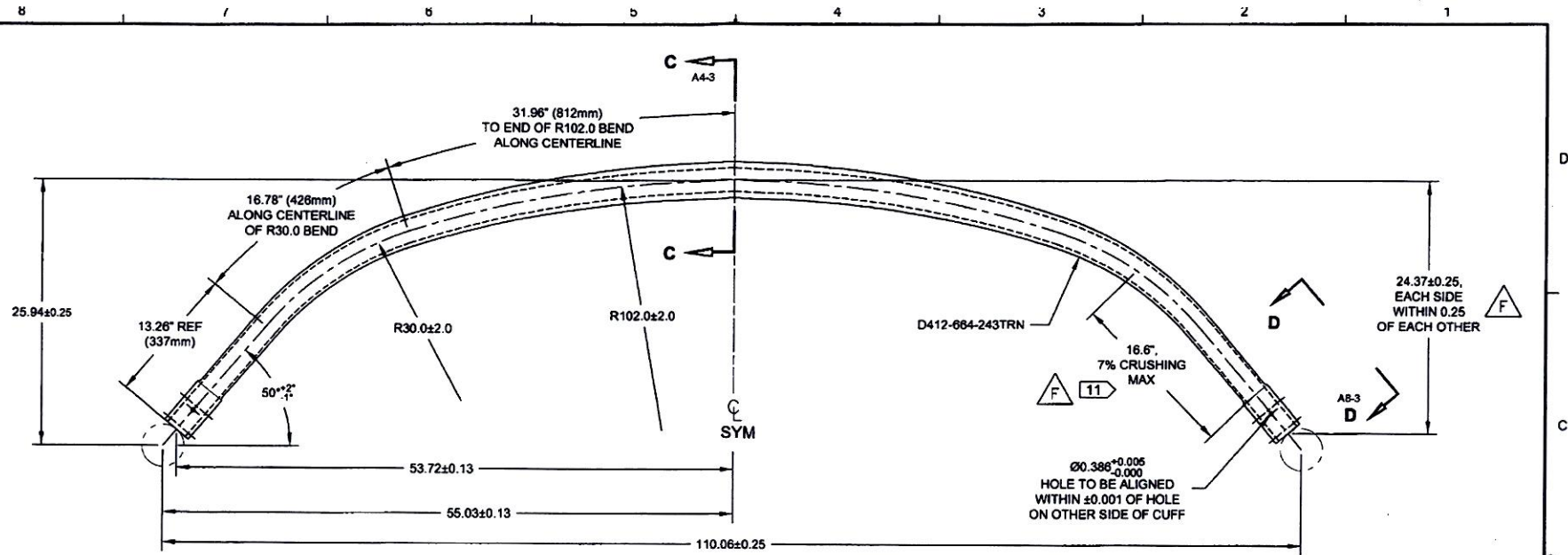
F	NOTES RE-ORDERED. SCOTCH-WELD WAS MAGNOBOND (C8-1), ADD CLAMP RETORQUE (A8-1), REMOVE ABRASION STRIP. ADD INSPECTION WINDOW (C8-1), CHAFING SHIELD NOW 4.38 WIDE (C6-2), ADD 7% CRUSHING (B8-1), CHG BEND HEIGHT TOL. TO ±0.25 (C1-3), CHG CUFF TOL. (D2-4), CLAMPS FLIPPED TO PREVENT CHAFING (B7-2, B7-3), INCORP. DEO E-2/4	CP	14.04.01
E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #8 PER PAR 08-046 (ZN A8-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D412-664-243	REV. F SHEET 1 OF 4
TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE NTS
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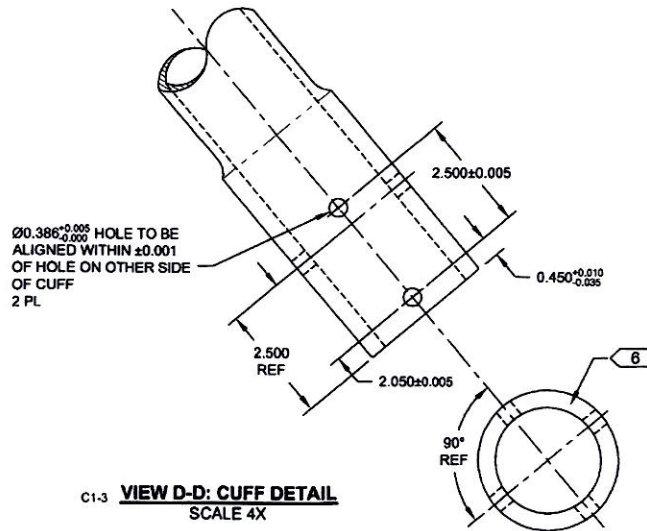


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2014-05-26

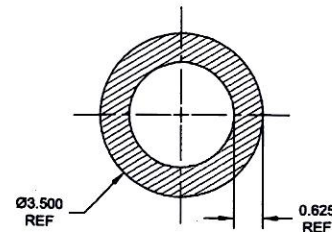
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D412-664-243	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D412-664-603
BENDING AND DRILLING DETAIL



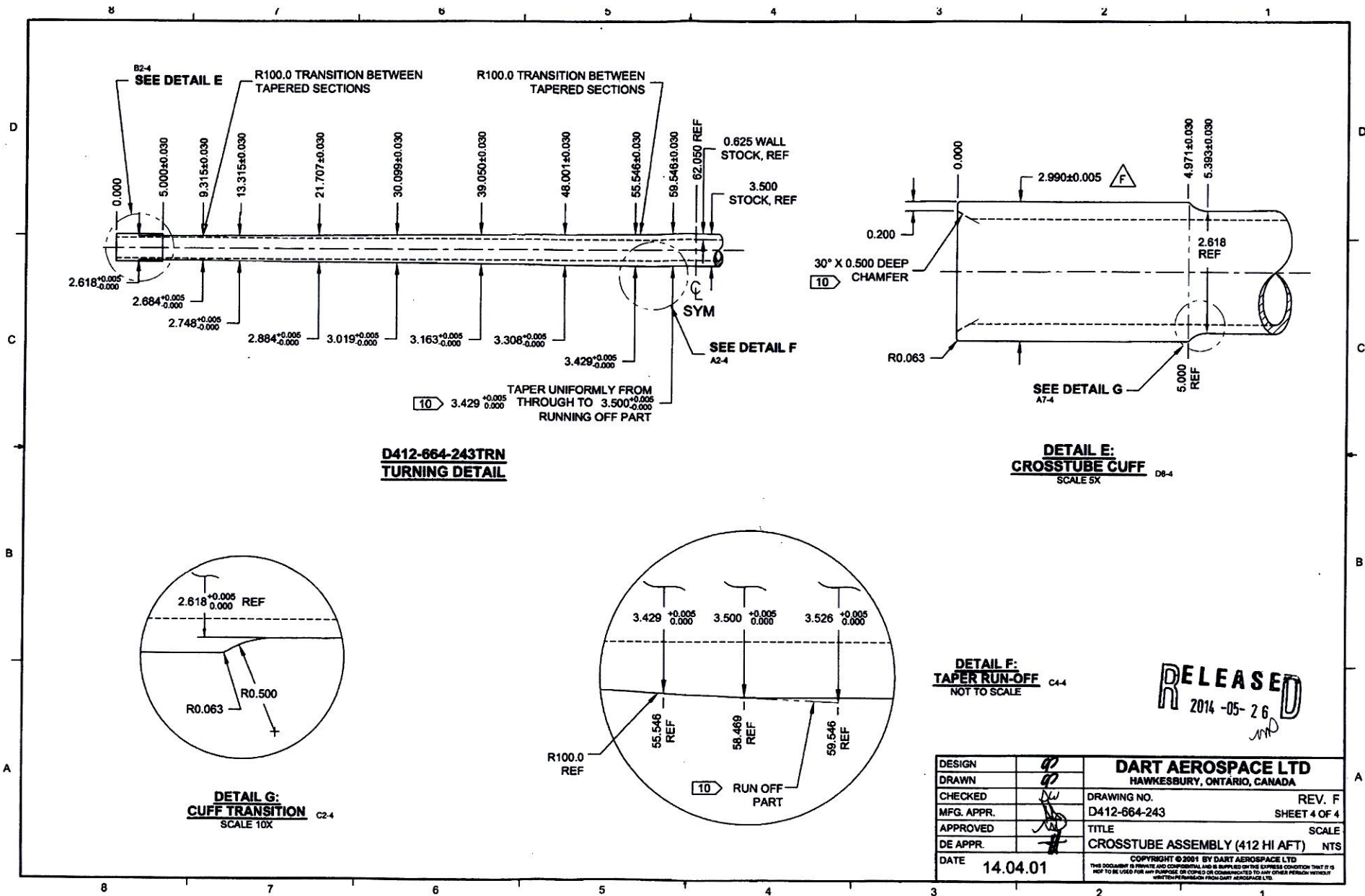
C1-3 **VIEW D-D: CUFF DETAIL**
SCALE 4X



SECTION C-C D5-3
SCALE 4X

RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D412-664-243	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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Reason	Parent Item ID	Lot Qty	Lot Nbr	Lot Trans Date	Avg Cost Amt	Last Cost Amt
150220	D2896-1	-1	145014	11/10/2016 13:03	320.515	402.3684
150220	D3189-1	-2	152560	11/10/2016 13:03	15.5517	19.4295
150220	D3595-063-570	-2	144834	11/10/2016 13:03	0.8199	0.8838
150220	D412-664-203TRN	-1	145021	10/25/2016 13:23	2186.8598	1794.7296
150220	MS21920-28	-2	M135009	11/10/2016 13:03	20.1289	19.99
150220	MS21920-28	-2	M135774	11/10/2016 13:03	20.1289	19.99
150220	MS21920-30	-2	m131689	11/10/2016 13:03	12.4358	12.24